

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave. St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011702**Date Inspected:** 25-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Zhao Chen Sun.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Heavy Dock(Tower Assembly), North Tower, Lift 1, Skin E, Bearing Stiffener(Outside Tower).

FCAW welding of Partial Penetration weld joint (PJP) NSD1-SA76F/H-28, 32; located on Heavy Dock(Tower Assembly), North Tower, Lift 1, Skin E. Welders are identified as 040367; ZPMC Quality Control Inspector (QC) is identified as Zhao Chen Sun. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2333-TC-P4-F.

Heavy Dock(Tower Assembly), North Tower, Lift 1, Skin D, Bearing Stiffener(Outside Tower).

FCAW welding of Partial Penetration weld joint (PJP) NSD1-SA22B/E-41, 37; located on Heavy Dock(Tower Assembly), North Tower, Lift 1, Skin D. Welders are identified as 050041; ZPMC Quality Control Inspector (QC) is identified as Zhao Chen Sun. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2333-TC-P4-F.

Heavy Dock(Tower Assembly), North Tower, Lift 1, Skin C, Bearing Stiffener(Outside Tower).

FCAW welding of Partial Penetration weld joint (PJP) NSD1-SA17F/G-37; located on Heavy Dock(Tower Assembly), North Tower, Lift 1, Skin C. Welders are identified as 054069; ZPMC Quality Control Inspector (QC) is identified as Zhao Chen Sun. The welding variables recorded by Quality Control Inspector (QC) appeared to

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

comply with the Applicable WPS: WPS-B-T-2333-TC-P4-F.

Heavy Dock(Tower Assembly), East Tower, Lift 1, Skin A, Bearing Stiffener(Inside Tower).

FCAW welding of Partial Penetration weld joint (PJP) weld joint ESD1-SA237D/F-5; located on Heavy Dock(Tower Assembly), East Tower, Lift 1, Skin A. Welders are identified as 062126; ZPMC Quality Control Inspector (QC) is identified as Zhao Chen Sun. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-2333-TC-P4-F.

This QA Inspector carried out NDE on following

Heavy Dock(Tower Assembly), East Tower, Lift 2, Skin E, Handrail.

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. This QA Inspector generated an MT report(TL-6028) for this date. The members are identified as

- 1) E76-53M-7-E
- 2) E76-53M-8-E
- 3) E74-65M-11-E
- 4) E74-65M-12-E
- 5) E74-65M-13-E
- 6) E74-77M-11-E
- 7) E74-77M-12-E
- 8) E74-77M-13-E
- 9) E74-65M-8-E
- 10) E74-65M-10-E
- 11) E74-77M-8-E
- 12) E74-77M-10-E

During random Magnetic Particle Testing (MT) of Handrail on East Shaft, Lift 2, 65M Elevation the Quality Assurance Inspector (QA) observed linear indications at fillet weld joint E74-65M-8-E. ZPMC provided the NDT Notification Sheet #005127 informing Caltrans QA that they have completed their NDT requirements. This indication was discovered inside of ZPMC personnel's testing area. Incident Report has been written on this issue on same date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 13482570045, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

(Continued Page 3 of 3)

Inspected By:	Juvekar,Amit	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
